Dart Aerospace Ltd. Friday, 5/25/2007 8:26:01 AM Date: Kim Johnston User: **Process Sheet** : LOCK PLATE Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number : 32620 : 10332 **Estimate Number** : NA : D2534 P.O. Number **Part Number** S.O. No. : NA : 5/25/2007 · D2534 REV D **Drawing Number** This Issue : N/A Prsht Rev. : NC Project Number : NA : SMALL /MED FAB First Issue **Drawing Revision** : 31830 : N/A Previous Run Material : 6/6/2007 Qty: 30 Um: Due Date Written By Checked & Approved By JLM Comment : Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-06-20 Additional Product Job Number: Seq. #: Machine Or Operation: Description: 1.0 M304S11GA 304/316 .125 Sheet Comment: Qty.: 1.3451 sf(s) 0.0448 sf(s)/Unit Total: 304/316 .125 Sheet (M304S11GA) Batch: M108 817 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D2734 Dwg Rev:_ Prog Rev:__ 2-Deburr if necessary 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0 COND CHECK QC8 Comment: SECOND CHECK

PACKAGING RESOURCE #1

Page 1

5.0

PACKAGING 1

Location:

Comment: PACKAGING RESOURCE #1 Identify and Stock

Each

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
Part No		DAR # Foult Catagony NC	D. V.	Alo DOA	. 6	Doto:	Nx. lx						

Part No:	PAR #: F	Fault Category:	NCR: Yes N	o) DQA: 🗔	🔰 Date: <u>(</u>	A/06/26
			QA: N/C	Closed:	_ Date: _	
NCR:	WOF	RK ORDER NON-CONFO	RMANCE (NCR)			
	Description of NC	Corrective Action	Section B	Varification	A	A

		Description of NC		Corrective Action Section B		Verification Section C	A = =====	Ammassal
DATE	STEP	Section A Init	Initial Chief Eng	Action Description Chief Eng	Sign & Date		Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date:

Friday, 5/25/2007 8:26:01 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOCK PLATE

Job Number: 32620

Part Number: D2534

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE







Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 87.0628

Dart Aerospace Ltd

W/O:		WORK ORDER CH	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No:	•	PAR #· Fault Category:	NCR: Yes	No DO	Δ.	Date:				

Part No: _	 PAR #:	Fault Category:	NCR: Yes N	o DQA:	Date:	_
			QA: N/C	Closed:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC Corrective Action Section				Verification	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector		
			,							
		•		·····						

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32620
Description: Lock Plate	Part Number:	D2534
Inspection Dwg: D2534 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

						
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.447	+0.006/-0.001	0.447	1		VerN	
R0.500	+/-0.010	RO, 500	1		RG	
R0.173	+/-0.010	RO. 173	7		R-G	
R0.096	+/-0.010	RO.096	V		R-G	
R0.125	+/-0.010	R=0.125	V		R-G	
R0.120	+/-0.010	R0.120	V		R-G	
R0.200	+/-0.010	RO.200	V		R-G	
0.125	+/-0.010	0.118	V		VerN	

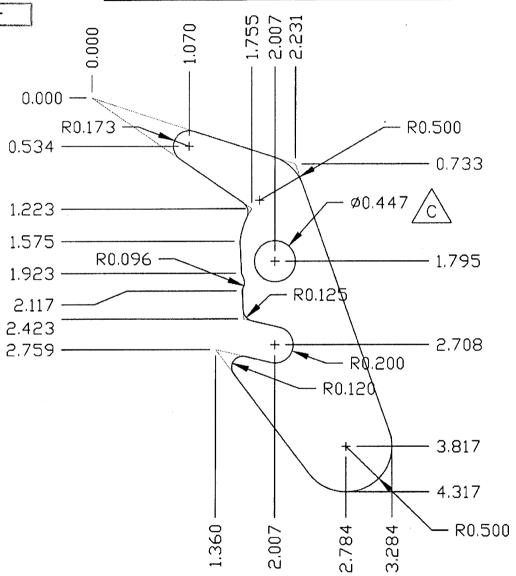
Measured by:	m.ml	Audited by:		Prototype Approval:	N/A
Date:	07 06 09	Date:	1706-11	Date:	N/A

Rev	Date	Change	Revised by	Approve/d
Α	07.03.14	New Issue	KJ/JLM A	



DESIG B W	N /ILLIAMS	DRAWN .BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHEC		APPROVED	DRAWING NO.	REV. D
	-111-	4	D2534 SHEET	1 OF 1
DATE			TITLE	SCALE
04.1	2.14		LOCK PLATE	1:1
C		96.07.26	HOLE WAS 0.328	
ח		04 12 14	LIPDATE NOTES	

RELEASED 04.12.16



D2534 LOCK PLATE

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 11 GAUGE (0.125 THICK) SHOP COPY (REF. DART SPEC. M304S11GA)

RETURN TO

2) FINISH: NONE

3) BREAK ALL SHARP EDGES TO 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RETURN TO ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER